

Work Order ID 62793

Friday, October 08, 2010 10:46:48 AM



POSITIVE RECALL
PRELIMINARY ISSUE

Page 1

Item ID: D4072-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Airframe Hinge

Start Date: 10/8/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 10/15/2010 Req'd Qty: 2.00

Customer:



Reference:

Approvals:

Process Plan: *PP*

Date: *10/10/08*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4072	<i>PP1 10-11-02</i>

100 Cut blanks as per folio 0.00



Bandsaw

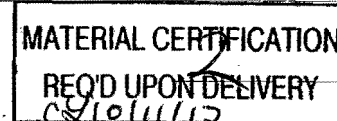
Memo

0.00

Jeaspa Bandsaw

CUT 2.125" LONG

SA 10/11/02



PTO

105 0.00



HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Mill as per Dwg an Folio FA938

Dwg Rev:

Folio Rev: *PP1*

Deburr

SA 10/11/02

2

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Item ID:	D4072-1	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Airframe Hinge					
Start Date:	10/8/2010	Start Qty:	2.00		Cust Item ID:	
Required Date:	10/15/2010	Req'd Qty:	2.00		Customer:	

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110 QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo SA 10/11/02	0.00 0.00				2			
120 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 Inspector to PBI Dry only 8/10/11/02 (X2) 0.00							
150 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 2) SA 10/11/03 0.00				2	0		

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Accept



Setup Start



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Cust Item ID:

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

Attestation Rec PB1
10.11.16

POSITIVE RECALL

EFFECTIVE DEC 02 AUTH W

RELEASED DATE

W.D.U.16

Picklist Print

Friday, October 08, 2010 10:46:53 AM

Page 1

Work Order ID: 62793

Parent Item: D4072-1

Parent Item Name: Airframe Hinge



Start Date: 10/8/2010

Required Date: 10/15/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: Ipp Rev:A New Issue 10-06-09 JLM Verified By:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.250X01.25 0		Purchased	No			100	f	7.2945	0.2	0.421053			



6061-T6 Bar 1.25 x 1.25



SA 10/11/02

6061T6 B 1.00 x 2.500
~~1.250 x 1.500~~

Location

MAT03

106259
110001

Loc Qty

7.294450526
7.06921053
0.22524

Loc Code

~~106259~~

For 10.11.02
This Batch Only.

M 103019

.3 ft SA 10/11/02

DART AEROSPACE LTD		Work Order: 62793
Description: Airframe Dimple		Part Number: N4072-1
Inspection Dwg: N4072 Rev: FBI		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.100	$\pm .010$	1.095	/			
.45	$\pm .030$.444	/			
.750	$\pm .010$.749	/			
$\varnothing .203$	$\pm .006$ $- .001$	$\varnothing .205$	/			
2.00	$\pm .030$	2.000	/			
$\varnothing .500 \times .125 \varnothing$	$\pm .010$	$\varnothing .501 \times .125$	/			
.375	$\pm .010$.375	/			
$\varnothing .323$	$\pm .006$ $- .001$	$\varnothing .324$	/			
.688	$\pm .010$.688	/			
.25	$\pm .030$.242	/			
R.13	$\pm .030$	R.125	/			
.275	$\pm .010$.277	/			
.125	$\pm .010$.124	/			
1.06	$\pm .030$	1.06	/			

Measured by: SA	Audited by: S	Preliminary Approval:		
Date: 10/11/02	Date: 10/11/02	Date:		
to FBI Day entry				
Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15

VPK METAL DART AEROSPACE

ALUMINUM FLAT BAR 6061-T6511
1.00" x 2.50" x 144.0000"
PART NO.

PO/Ref PO00002699

We certify that this is a true copy of the report
furnished by the producer of the metal, or data
resulting from tests made in approved labs.

Certificate of Mill Test Results

BL PEC-444141-002 19Dec06

Signed by _____ Pg 1/1

Attn: 444141

CUSTOMER ORDER NO.: PEC-63307
CUSTOMER PART NO: 1-1000-2500



MILL TEST REPORT

CUSTOMER: PECKOVERS (VPK METAL INC.)
2821 LANGSTAFF ROAD
CONCORD, ON L4K 5C6

SAMPLE (S) OF ALUMINUM

REPORT: 48840

DIE NO.	S-4655
DESCRIPTION	2.5"X1" FLAT BAR <i>mk</i>
AL. ALLOY & TEMPER	6061/T6511
EXTRUDEX ORDER NO.	87573-7-A.11
SPECIFICATION	ASTM B221
SILICON %	0.59
IRON %	0.27
COPPER %	0.20
MANGANESE %	0.04
MAGNESIUM %	0.85
CHROMIUM %	0.07
ZINC %	0.05
TITANIUM %	0.02
ALUMINUM %	REMAINDER
ALLOY TYPE %	6061
ALLOY CAST NO.	876
YIELD STREGTH (IN ksi)	38.0
TENSILE STREGTH (IN ksi)	43.4
ELONGATION % IN 2"	14.0
HARDNESS (ROCKWELL 'F')	88.7 88.1 87.1

N.J.
N.RAMPERTAB
(LAB. TECH.)
NOV-06-06

DATE:

411 Chrislea Road. Woodbridge, Ontario. L4L 8N4 TEL:(416) 745-4444 FAX:(416) 745-0925